



Dart Aerospace Ltd.
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D2594-1

Job Sheet 209058



Black Sandflex on

Part No: D2594-1

Job Qty: 32 pcs

Part Name: Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/20

Job Tracking No:

Due Date: 4/15/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP D 02.08.22 Make in Cobra KJ IPP E 06.12.11 ecn 836 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	32 pcs		4/14/20	0.01 0.92	Hardinge - 1		<i>SL 20-4-15</i>
110	QC 2	32 pcs		4/14/20	0.00 0.00	QC 2 - 1		
						QC 2 - 12		
						QC 2 - 14		
						QC 2 - 17		
						QC 2 - 19		
						QC 2 - 2		
						QC 2 - 20		
						QC 2 - 22		
						QC 2 - 23		
						QC 2 - 25		<i>SL</i>
						QC 2 - 32		
						QC 2 - 33		
						QC 2 - 35		
						QC 2 - 39		
						QC 2 - 4		
						QC 2 - 40		
						QC 2 - 44		
						QC 2 - 45		
						QC 2 - 48		
						QC 2 - 49		
						QC 2 - 50		
						QC 2 - 51		
						QC 2 - 52		
						QC 2 - 57		
						QC 2 - 62		
						QC 2 - 63		
						QC 2 - 8		
						QC 2 - 66		
						QC 2 - 64		

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Container No: S270623



Part: D2594 - 1

Job No: 209058

Serial No/Batch: S270623

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/16/20

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
120 QC 8	32	4/14/20	0.00 0.00	QC 8 - 12	
	pcs			QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	8/20-04-15
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
130 Handfinish - 1-1 Chemical-B4B	32	4/14/20	0.00 0.30	Handfinish - 1 - 1 - B4B	BEB 20-04-16.
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 -	

					B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
135 Powdercoat - 1 White Gl(A)- B4B	32 pcs	4/15/20	0.00	0.05	Powdercoat - 1 - B4B	
<i>M156410</i> <i>Black Sndtex FINISH 7.55</i> <i>av. 300°</i>					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	<i>20 04-21</i>
					Powdercoat - 4 - B4B	
					QC 3 - 10	
150 QC 3	32 pcs	4/15/20	0.00	0.00	QC 3 - 13	
					QC 3 - 15	<i>ML 20-4-21</i>
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
160 Packaging 3-1 - Stock - B4B	32 pcs	4/15/20	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	

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DAS
15
3-89

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	FP-001
				Packaging 3 - 16 - B4B	20-4-21
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
170 QC 21 - SA	32 pcs	4/15/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	988

Mark container
B/LK Bucker

APR 21 2020

Part Op 100 - (Hardinge) 1-Make as per Dwg D2594-1 and Folio FA262.
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Chemical Conversion Coat per QSI005 4.1)
 135 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 150 - (QC3- Inspect Part Finish)
 160 - (Identify as per dwg & Stock Location: _____) LOCATION : FP001
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.625	6061-T6 Round Bar .625"	1.6672 ft (.0521 ea)	100-Hardinge - 1	5150604

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6R0.625	2	28	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	0.060inches ± 0.005	0.065 0.055	-06	VERU SL-2
2	Plug	0.500inches ± 0.010	0.510 0.490	-501	"
3	Plug	0.625inches ± 0.010	0.635 0.615	-624	"
4	Plug	0.430inches + 0.000 - 0.002	0.430 0.428	-429	mic SL-9
5	Plug	0.090inches + 0.000 - 0.002	0.090 0.088	-189	VERU
6	Plug	0.045inches + 0.000 - 0.002	0.045 0.043	-044	"